



Dart Aerospace Ltd.
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D2842-042
Job Sheet 181170



Part No: D2842-042

Job Qty: 2 ea

Part Name: Step Assembly RH, 206 Float



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/23/18

Job Tracking No:

Due Date: 9/5/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV C IPP Rev:D As Per Ecn 766 06-01-06 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		9/5/18	0.00	0.00	Start Up Large Fab-4		
100	Large Fab	2 pcs		9/5/18	0.00	2.88	Large Fab 8		
105	QC	2 pcs		9/5/18	0.00	0.00	QC6		
110	Large Fab	2 pcs		9/5/18	0.00	2.88	Large Fab 2		
120	QC	2 pcs		9/5/18	0.00	0.00	QC9		
130	QC	2 pcs		9/5/18	0.00	0.00	QC5		
140	HandFinish	2 pcs		9/5/18	0.00	0.82	HandFinish1		
150	QC	2 pcs		9/5/18	0.00	0.00	QC7-1		
160	Large Fab	2 pcs		9/5/18	0.00	2.88	Large Fab 2		
170	QC	2 pcs		9/5/18	0.00	0.00	QC10		
180	QC	2 pcs		9/5/18	0.00	0.00	QC5		
185	HandFinish	2 pcs		9/5/18	0.00	0.82	HandFinish2		
190	Powdercoat	2 pcs		9/5/18	0.00	0.35	Powdercoat1		
200	QC	2 pcs		9/5/18	0.00	0.00	QC3		
210	HandFinish	2 pcs		9/5/18	0.00	0.82	HandFinish3		
220	QC	2 pcs		9/5/18	0.00	0.00	QC5		
230	Packaging	2 pcs		9/5/18	0.00	0.00	Packaging3-1		
240	QC21-SA	2 Ea		9/5/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut D2842-1 using D2622 extrusion as per Dwg D2842 2-Drill D2842-1 using Jig DT8272 as per Dwg D2842
Descriptions: ***DO NOT OPEN HOLES*** 3-Deburr and bevel ends for welding

110 - 1-Weld one end cap and (2) lugs using DT10058 as per Dwg D2842 2- OPEN HOLES TO SIZE AS PER DWG (0.250") 3-Grind end cap weld flush

160 - 1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.

185 - ***Touch up step with alodine per qsi 005 prior to powder coat***

190 - START TIME: 11:00

210 - 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: 5098/20

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wing walk 5098/20

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2 Ea (1 ea)	90-Start up Operation	S 104 007
D2734	Step End Plate	4 Ea (2 ea)	90-Start up Operation	S 077 383
D3459-1	Float Step Mounting Plate	4 Ea (2 ea)	90-Start up Operation	S 011 655
D3459-3	Float Step Mounting Plate	4 Ea (2 ea)	90-Start up Operation	S 115 021
MS27039C1-07	Screw	6 Ea (3 ea)	210-HandFinish	FM132317-10
NAS1149C0332R	Washer	6 Ea (3 ea)	210-HandFinish	S089465
NAS1329C3KB130	Insert	6 Ea (3 ea)	210-HandFinish	S023251
NAS1515H3L	Washer	6 Ea (3 ea)	210-HandFinish	S083559.

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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	2	11	0
	D2734	4	34	0
	D3459-1	4	12	0
	D3459-3	4	15	0
210-HandFinish	MS27039C1-07	6	38	0
	NAS1149C0332R	6	5,762	0
	NAS1329C3KB130	6	84	0
	NAS1515H3L	6	599	0

Part Specifications

Specifications could not be found.

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Container No: S120005



Part: D2842-042

Job No: 181170

Serial No/Batch: S120005

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/21/18